

# Work Order ID 48540

June 26, 2009 7:33:02 AM



Page 1

Item ID: D3255-5

Accept



Setup Start



Revision ID: B

Stop



Item Name: Gasket

Start Date: 15/07/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3255

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3255 Dwg Rev: B Prog Rev: B 2-Deburr  
if necessary

HB 97-1

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 97-1



120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

- 50267101



**Work Order ID 48540**

June 26, 2009 7:33:02 AM



Page 2

Item ID: D3255-5

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Start Date: 15/07/2009 Start Qty: 6.00



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Required Date: 03/08/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Packaging

Identify as per dwg & Stock Location: 80

0.00

9/7/11

SP



Memo

0.00

Packaging

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/07/09 df  
WF 09-07-08

# Picklist Print

June 26, 2009 7:33:01 AM

Work Order ID: 48540



Parent Item: D3255-5RevB



Parent Item Name: Gasket



Start Date: 15/07/2009

Required Date: 03/08/2009

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3255RevB  Gasket		Manufactured	No			110	sf	0.0000	9.7333 ✓ 			

## List Lots

July 8, 2009 12:51:59 PM

Page 1 of 1

Criteria : All Items All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
MSIL60S.063 High Temp Silicon Sheet 0.063"	Main Warehouse ST	110311		20.6700		QC21	
Total:				20.6700			
MSIL60S.125 high temp. silicone sheet .125	Main Warehouse ST	110311	07/07/2009	31.5998		QC21	
Total:				31.5998			

Date: Friday, 12/06/2009 9:55:10 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	GASKET
<b>Job Number</b> :	48540		
<b>Estimate Number</b> :	10433		
<b>P.O. Number</b> :		<b>Part Number</b> :	D32555
<b>This Issue</b> :	12/06/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3255 REV B
<b>First Issue</b> :	1/1	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	46858	<b>Drawing Revision</b> :	B
<b>Written By</b> :		<b>Material</b> :	
<b>Checked &amp; Approved By</b> :	<u>12.09.06.12</u>	<b>Due Date</b> :	19/06/2009
<b>Comment</b> :	Est A 04.05.12 New issue KJ/RF		
	Est Rev:B Now On Waterjet 06-08-14 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	✓ D3255	Gasket
-----	---------	--------



**Comment:** Qty.: 1.6182 Each(s)/Unit Total : 9.7089 Each(s)

Gasket use D3255

.063" thick silicone coated fiberglass

Batch: 103111B 9-7-1

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

**Comment:** FLOW WATER JET

1-Cut as per Dwg D3255

Dwg Rev: BProg Rev: B1B 9-7-1

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

1B 9-7-1**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 12/06/2009 9:55:11 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 48540

Part Number: D32555

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



✓

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

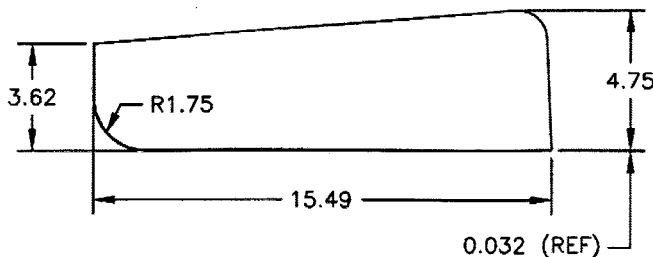
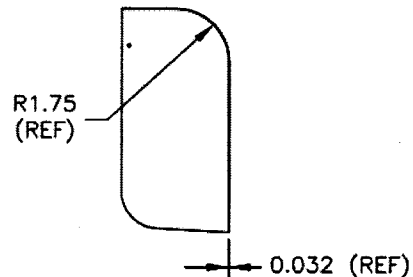
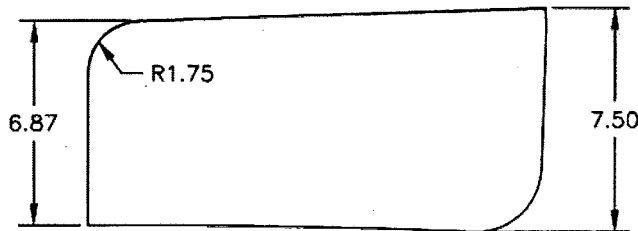
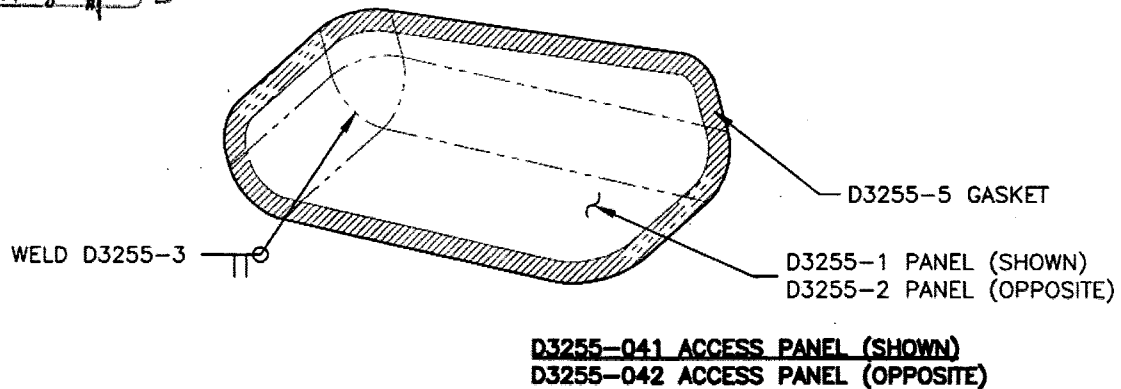
**NOTE:** Date & initial all entries





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A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

**RELEASED**  
05.01.18 #

**D3255-1 BEND DETAIL**  
**D3255-2 OPPOSITE**

**D3255-041/-042 NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

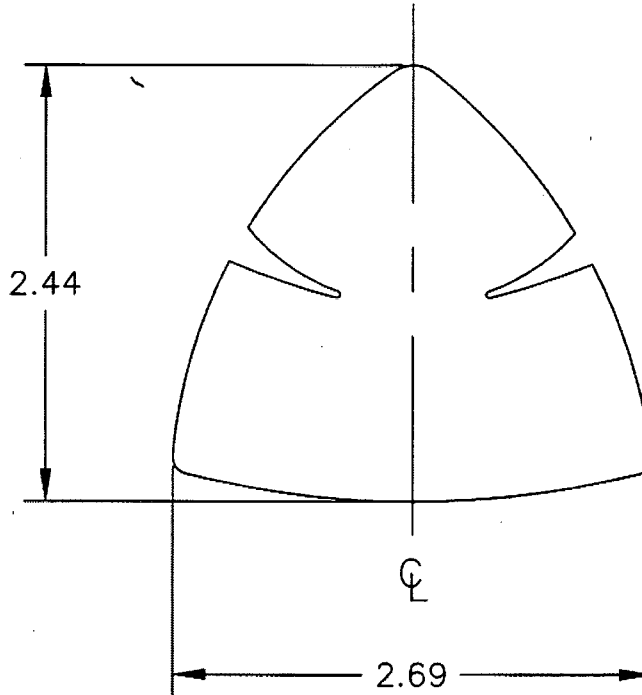
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DATE 04.12.06		TITLE TITLE	SCALE 1:1

**RELEASED**  
05-01-18 [Signature]

**D3255-3 CAP**  
**FORM TO FIT D3155-1/-2**

**D3255-3 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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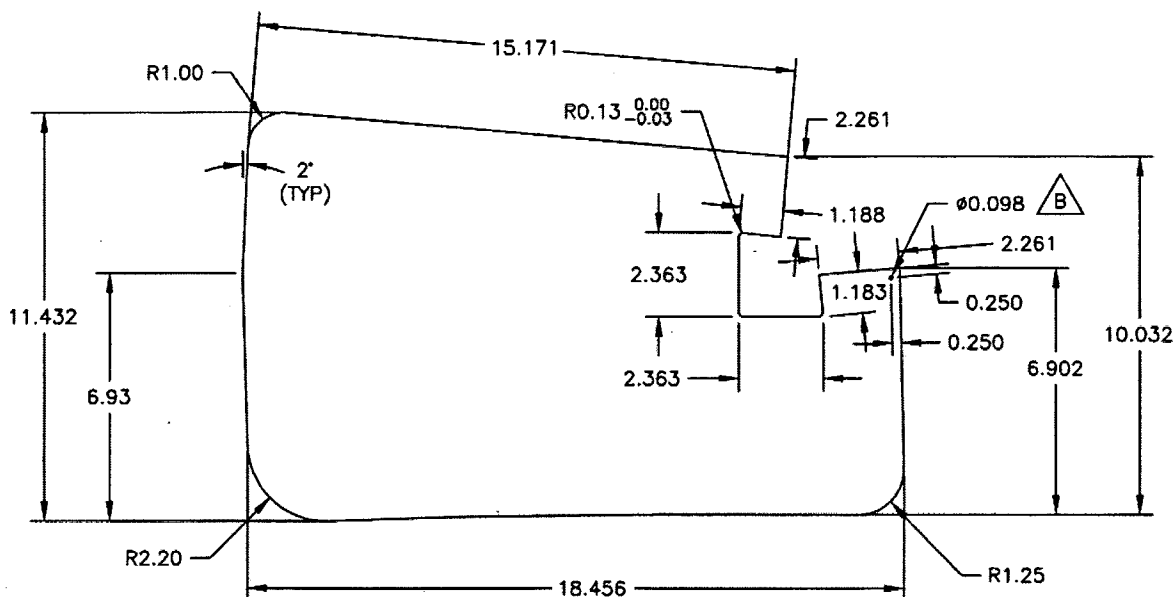
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RELEASED  
05-01-18



### D3255-1/-2 FLAT PATTERN

#### D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

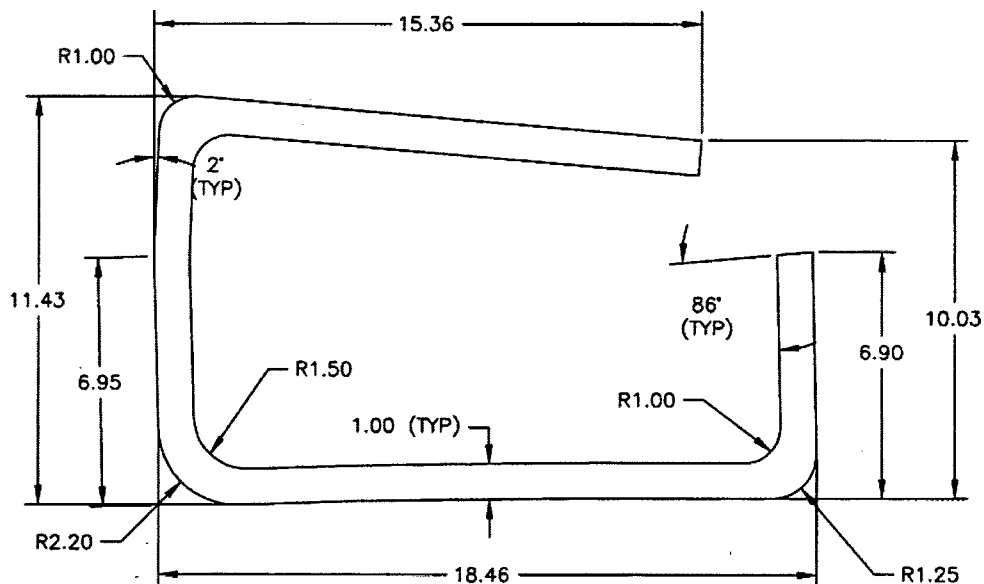
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**RELEASED**  
05.01.18 #**D3255-5 GASKET****D3255-5 NOTES:**

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F  
P/N SIL/F 36x36x1/16  
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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